



Dart Hawkesbury
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D4635-142
Job Sheet 167085-C



Part No: D4635-142

Job Qty: 1 ea

Part Name: Fwd Ceiling Replacement Panel Assembly, RH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/24/17

Job Tracking No:

Due Date: 11/10/17

Created By: Mario Poulin

Type: SOLD

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	1 Ea		11/9/17	0.00	0.00	Start Up Small Fab	50
100	Small Fab	1 pcs		11/9/17	0.00	0.80	Small Fab	
110	Small Fab	1 pcs		11/10/17	0.00	0.80	Small Fab	
120	QC	1 pcs		11/10/17	0.00	0.00	QC5	
130	Packaging	1 pcs		11/10/17	0.00	0.00	Packaging3	
140	QC21-SA	1 Ea		11/10/17	0.00	0.00	QC21	

Part Op 100 - Pick Kit

Descriptions: 110 - Assemble as per Dwg D4635-142 Bond foam core to inside of panel 3M Scotch Weld 1300

Batch: _____ 1- Scuff bonding surface to eliminate in-perfections and increase bonding and clean with wash& wipe 2- Locate and glue down Channel Assy, angles, brackets, and mounting pads using 3M Plastic welder II.(see note 8) Batch # _____ Expiry Date _____ 3- Apply labels as per Dwg. and seal with 3M 3950 edge sealer(see note 9) Batch: _____

120 - QC5- Inspect part completeness to step on W/O

130 - Identify as per dwg & Stock Location: _____

140 - QC21- Final Inspection - Work Order Release

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D4635-2 5026255	1	2	0	0
	D4669-1	2	27	0	0
	D4695-042 5022842	1	1	0	0
	D4732-3 5022839	1	4	0	0
	D4732-31 5022837	1	4	0	0
	D4732-35 5022836	1	5	0	0
	D4732-7 5022835	1	2	0	0
	D5022-1 5025241	1	4	0	0

Part Specifications

Specifications could not be found.

Plex 10/24/17 10:42 AM dart.poulin.mario

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Water Jet ☐ Engineering ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Quality ☐ Forming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐ Composite ☐ Supplier ☐			
Date: _____ Step #: _____		S		MRB (QSI042) Approval			
Description Work Order				Completed By			
				Lead hand / Supervisor Approval Verification			
				QC / QA Coordinator Approval			

Job No: 167085-C
 Mfg Date: 12/22/17

Start up Operation

D4635-142

PART NO:
 Revision:
 Operation:
 Change No:

Fwd Ceiling Replacement Panel Assembly, RH

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 DART AEROSPACE

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Root Cause			
Environment	☐ No Re-verification	☐ Pressure/Force	☐
Design	☐ Operator	☐ Bending	☐
Doc/Data	☐ Offset/Setup	☐ Centre Not Concentric	☐
Equip/Tooling	☐ Supplier	☐ Cracks	☐
Handling/Pre	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐
Material	☐ Use for Testing	☐ Cuffs	☐
Internal Transport	☐ Poor Information	☐ Crushing	☐
Tribal Knowledge	☐ Rushing	☐ Heat Treat	☐
LOA	☐ Product Improvement	☐ Wave/Twist in Tube	☐
Substation	☐ Process Improvement	☐ Marks/Chatter	☐
Past Expiry Date	☐ Manufacturing Process		
Misidentified	☐ Past Due	OTHER :	

☐ Positioned Wrong
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Drawing
☐ Finish
☐ Misread
☐ Turning Sequence